

Date: Thursday, 13/11/2008 9:25:59 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CENTER DIVIDER
Job Number : 43078	
Estimate Number : 10880	
P.O. Number :	Part Number : D3251041
This Issue : 13/11/2008 S.O. No. :	Drawing Number : D3251 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 43078	Material :
Written By :	Due Date : 20/11/2008 Qty: 3 Um: Each
Checked & Approved By : <u>JUD 08.11.12</u>	
Comment : Est. B 04.10.26 D3251-1 no longer made in-house est C 08.11.13 in-house EC verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 3.5805 sf(s)/Unit Total : 10.7415 sf(s)
 2024-T3 .063 sheet
 batch: 109463 1B 8-11-13

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3251
 Dwg Rev: A
 Prog Rev: A

1B 8-11-13

2-Deburr if necessary

1B 8-11-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 8-11-13

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Sos 11/14 (X3)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend as per dwg D3251

S08/11/18(3)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/18 (X3)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

08-11-18

(XB)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

508/18 (XB)

9.0

D32481

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

2 D3248-1 Doubler

B21809 (2)

B22636 (4)

FF 08/02/09

10.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 18.0000 Each(s)/Unit Total : 54.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

18 MS20470AD4-5Rivet

M106918

Assemble D3251-041 as per Dwg D3251

FF 08/12/09

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3251

FF 08/12/09

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/18 (XB)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



M 10 S 642



(3X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:15
320°F
7:45

m-f 08/12/10

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



41



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-10

(x3)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/12/10 (3)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

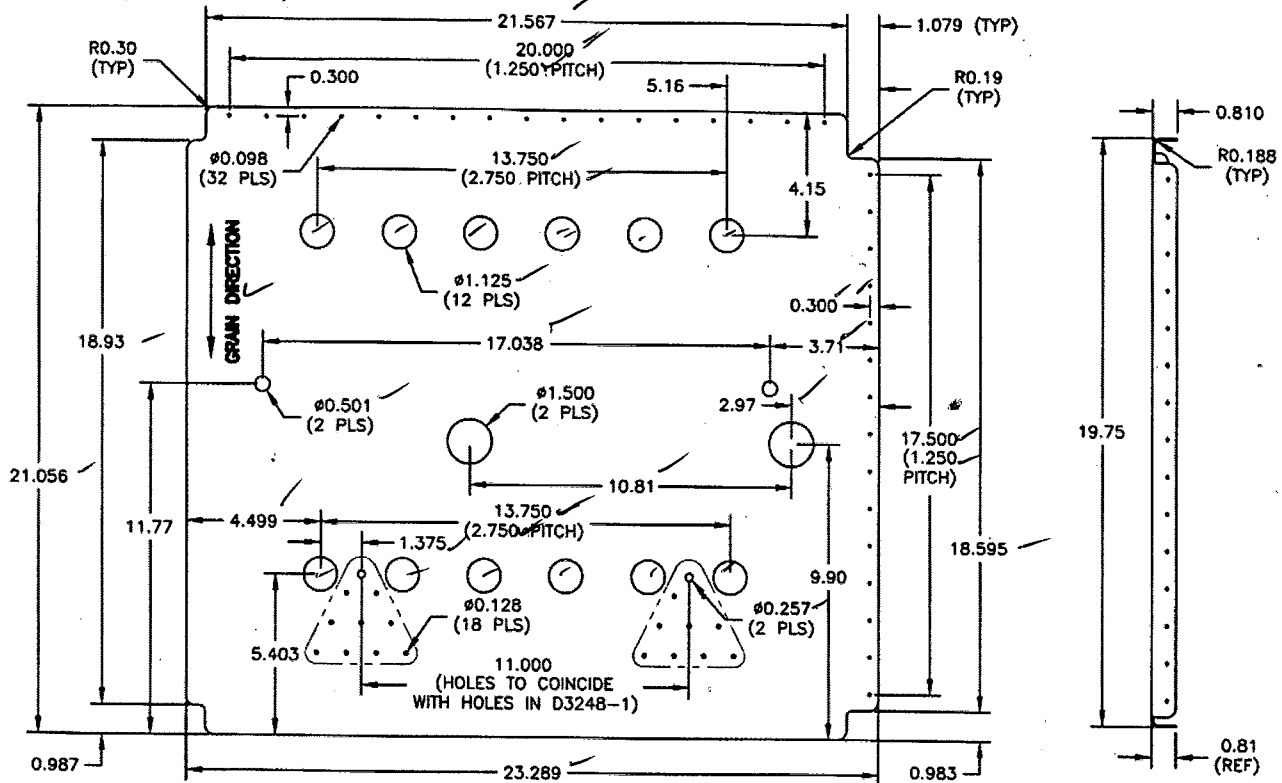


mf 08-12-10

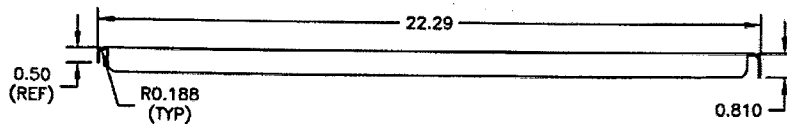
DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3251	REV. A SHEET 1 OF 1
DATE 04.04.06	TITLE CENTRE DIVIDER (DUAL BATTERY RACK) 1:6	SCALE	
A	04.04.06	NEW ISSUE	

RELEASED
04.05.04



FLAT PATTERN

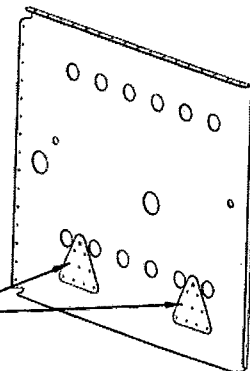


D3251-1 BEND DETAIL

INSTALL D3248-1
USING MS20470A4-5
RIVETS

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



SHOP COPY
RETURN TO
ENGINEERING

D3251-04 UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 12078

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DART AEROSPACE LTD		Work Order: 43078
Description: CENTER DIVIDER		Part Number: D3251-1
Inspection Dwg: D3251, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.102	X			
Ø .128	+ .005 - .001	.130	X			
Ø .257	+ .006 - .001	.257	X			
Ø 1.125	+ .012 - .001	1.125	X			
Ø 1.500	+ .012 - .001	1.500	X			
Ø .501	+ .006 - .001	.502	X			
.306	+/- .010	.305	X			
20.000	+/- .010	20.000	X			
21.567	+/- .010	21.567	X			
5.16	+/- .030	5.161	X			
4.15	+/- .030	4.152	X			
1.079	+/- .010	1.080	X			
3.71	+/- .030	3.71	X			
17.038	+/- .010	17.038	X			
13.750	+/- .010	13.750	X			
2.750	+/- .010	2.747	X			
17.500	+/- .010	17.500	X			
1.250	+/- .010	1.248	X			
18.595	+/- .010	18.595	X			
.983	+/- .010	.985	X			
1.375 13.750	+/- .010	1.375	X			
4.499	+/- .00	4.499	X			
1.375	+/- .010	1.375	X			

Measured by: KB
Date: 8-11-13

Audited by: S
Date: 08/11/14

Prototype Approval: n
Date: 9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

P/O D3251-041

[Handwritten signature]

